

90F50

ARC

Order # 18695

DART
AEROSPACEDart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
CanadaTel (613) 632-5200
Fax 613 632-5246JAN 27 13
C/L

D350-591-312

Job Sheet 201570



Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 11/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	11/18/19		0.00	10.00	Large Fab - 1		Sten
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	10 pcs	11/18/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	10 pcs	11/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19	DAS	
							QC 5 - 22	24	
							QC 5 - 24	9-89	
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

Plex 10/7/19 3:07 PM Dart.lajeunesse.marie

140 Handfinish - 1-1 Chemical-B4B	10 pcs	11/18/19	0.00	1.87	QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	BEB 19-10-26
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	10 pcs	11/18/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	DAS OCT 28 2019 40 9-39
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	

10/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 Large Fab - Steps - 2 - B4B	10 pcs	11/18/19	0.00 10.00	QC 7 - 79	
				Large Fab - 1 - B4B	SLH
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B	
				(Various)	
190 QC 10	10 pcs	11/18/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
200 QC 5	10 pcs	11/18/19	0.00 0.00	QC 5 - 10	DAS OCT 29 2019 68 9-89
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS OCT 29 2019 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 Handfinish - 1-2- Chemical- B4B	10 pcs	11/18/19	0.00 1.87	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	DAS OCT 30 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

Plex 10/7/19 3:07 PM Dart.lajeunesse.marie

220 Powdercoat - 1 White GI(A)- B4B	10 pcs	11/18/19	0.00 2.98	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
230 Handfinish - 3-1- WingWalk- B4B	10 pcs	11/18/19	0.00 1.87	Powdercoat - 3 - B4B	BL 19-10-31.
				Powdercoat - 4 - B4B	
				Handfinish - 3 - 1 - B4B	19-11-01
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
240 QC 3	10 pcs	11/18/19	0.00 0.00	Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	DAS 81 9-89
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
250 Packaging 1-1 - Pick Kit - B4B	10 pcs	11/18/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	

						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
						Packaging 1 - 28 - B4B	
						Packaging 1 - 29 - B4B	
						Packaging 1 - 30 - B4B	
						Packaging 1 - 31 - B4B	
						Packaging 1 - 32 - B4B	
						Packaging 1 - 33 - B4B	
						Packaging 1 - 34 - B4B	
						Packaging 1 - 35 - B4B	
						Packaging 1 - 36 - B4B	
260	QC 4	10 pcs	11/18/19	0.00	0.00	QC 4 - 28	
						QC 4 - 58	
						QC 4 - 69	
						QC 4 - 9	
						QC 4 - 46	
						QC 4 - 68	
						QC 4 - 72	
						QC 4 - 74	
						QC 4 - 75	MB 11/25/2019
						QC 4 - 78	
270	Packaging 3-1 - Stock - B4B	10 pcs	11/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	MB 11/25/2019
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	NOV 25 2019
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	DAS 21
275	DC - 1 - B4B	10	11/18/19	0.00	0.00	DC - 1 - B4B	

280 QC 21 - FG	pcs	10	11/18/19	0.00	0.00	DC - 2 - B4B	
	pcs					QC 21 - FG - 21	
						QC 21 - FG - 70	
						QC 21 - FG - 53	

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 10:20 OVEN TEMPERATURE: 320°

FINISH TIME: 10:50 11/18/19

230 - Wing Walk as per dwg QSI005 4.4 Batch _____

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	S220700
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	S223692
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	S226412
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	S225458
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	S223190
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	3K1257
AN3-357	Bolt	1 20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S180000
AN4-10A	Bolt	72 80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
AN4-10A	Bolt	18 20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
D2236-1	Mounting Lug	7 40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
D2619	Bushing	18 20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
D2856-400-720	Abrasion Strip 4" X 7.20"	18 20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
D3236-1	Mounting Lug	18 20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
D3278-041	Support Assembly	9 10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
MS21042L3	Nut	18 20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
MS21042L4	Nut	92 80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
MS21042L5	Nut	18 20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
WAS-149D03F3	Washer	36 40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
WAS-149D03F3	Washer	14 160 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000
WAS-149D03F3	Washer	36 40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	S220000

1- 12615

2- 12654 ✓

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	19	0
	D3219-1	20	123	0
	D3272-1	10	0	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	21	0
	D3066-1	20	68	0
	MS20600-AD4W4	160	819	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	110	0
	AN4-13A	80	614	0
	AN5-36A	20	98	0
	D2230-3	40	201	0
	D2618	20	222	0
	D2856-400-720	20	98	0
	D3235-1	20	98	0
	D3278-041	10	2	0
	MS21042L3	20	3,147	0
	MS21042L4	80	1,489	0
	MS21042L5	20	320	0
	NAS1149D0363J	40	498	0
	NAS1149D0463J	160	2,429	0
	NAS1149D0563J	40	1,159	0

Part Specifications

Specifications could not be found.

Plex 10/7/19 3:07 PM Dart.lajeunesse.marie

Route update only

100

PAGE 1 OF 2

1

2000

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2882-001	MOUNTING LUG
2	2	2	2	2	2	D2882-002	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2882-003	ABRASION STRIP
2	2	2	2	2	2	D2882-004	MOUNTING LUG
				1	1	DSI 9410-011	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN2-25A	BOLT
				8	8	AN4-15A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-20A	BOLT
4	4	4	4	4	4	NAS1140D0462-1	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1140D0462-1	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1140D0462-1	WASHER (AN960JD516)
2	2	2	2	2	2	MS21419L3	NUT
6	6	6	6	8	8	MS21419L4	NUT
2	2	2	2	2	2	MS21419L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.